Work Order ID 100057 *100057* Page April-17-13 1:06:40 PM Item ID: D4005-1 Accept *N900040100* Setup Start Revision ID: Rear Restraint Angle Gutter Item Name: **Start Date:** 4/17/13 Start Qty: 6.00 Cust Item ID: Required Date: 5/01/13 Req'd Qty: 6.00 **Customer:** Reference: Run Approvals: Process Plan: MCゴ Date: 304-17 Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D4005 В 100 DAS 05 12 0.00 *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg Dwg Rev:_ Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110*

0.00

Memo

QC

Quality Control

NCR: Ye	es / No	1			WORK ORDER NON-O	CONFORI	MANCE / UPE	DATE	QA Closed:	Date	:
Work Order		1 1 1			DISPOSITION		,	AGAINST DE	EPARTMENT	/PROCESS	
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	Turning S	equence			Finish	Out of	Sequence	į :			
	Wave/Tw	rist in Tub	эe		Teolio	Outside	e Dimensions				·

DQA: ____ Date: ____

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 100057 *100057*

1pril-17-13 1:06:40 PM

Item ID:

D4005-1

Accept

N900040100

Setup Start

Revision ID:

Item Name:

Required Date: 5/01/13

Rear Restraint Angle Gutter

Start Date:

4/17/13

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID 120

Operation Description

QC8- Inspect parts - second check

Set Up/ Run Hours 0.00 **S**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp.

Number Stamp

120

Quality Control

QC

Memo

0.00

130

130

Brake NC

Brake NC

Bend as per dwg

Memo

0.00

0.00

135

QC5- Inspect part completeness to step on W/O

135 QC

Quality Control

Memo

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-	Turning Sequence Finish						Out of Sequence						
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100057

Work Order ID 100057 April-17-13 1:06:40 PM

Item ID:

D4005-1

Accept

N900040100

Setup Start

Revision ID: Item Name: **Start Date:**

Required Date: 5/01/13

Rear Restraint Angle Gutter

4/17/13

Start Qty: 6.00 Req'd Qty: 6.00

Operation

Description

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Reject

Oty

Number Stamp

Insp.

Sequence ID/ Work Center ID 140

1/10

HandFinish

Hand Finishing

Memo

Chemical Conversion Coat per OSI005 4.1

0.00

0.00

Accept

Qty

Reject

Quality Control

Memo

QC7-Inspect Chemical Conversion Coat

0.00

0.00

6xym/13/04/25

150

145

Gloss Grey (4.3.5.15) per QSI 005 4.3

150 Powdercoat

Powder Coating

Start Time: Oven Temperature:

Finish Time:

47-16

6xxmf 13/04/25

W118533

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100057

Work Order ID 100057 April-17-13 1:06:40 PM

Item ID: D4005-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Rear Restraint Angle Gutter **Start Date:** 4/17/13 Start Oty: 6.00 Cust Item ID: Required Date: 5/01/13 Req'd Qty: 6.00 **Customer:** Reference: Run **Approvals:** Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 160 QC3- Inspect Part Finish 0.00 *160* 0.00 Memo Quality Control 164 0.00 *164* Small Fab 0.00

166

Small Fab

QC5- Inspect part completeness to step on W/O

1-Install abrasion strip and trim excess as per dwg (note 8)

Quality Control

OC

Memo

Memo

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		Turning Se	,		<u> </u>	Finish	\vdash	1	Sequence				
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100057

Work Order ID 100057 April-17-13 1:06:40 PM

Required Date: 5/01/13

D4005-1

Accept

N900040100

Setup Start

Item Name: **Start Date:**

Revision 1D:

Item ID:

4/17/13

Start Qty: 6.00 Req'd Qty: 6.00

Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Rear Restraint Angle Gutter

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Stop

Sequence ID/ Work Center ID Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

Packaging Packaging

170

Memo

0.00

0.00

180

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

180

Quality Control

Memo

0.00

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NCR: Y	es¦	/ No	1		ń	WORK ORDER NON-C	CON	IFOR!	MANCE / UPDA		_		
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	_	Wave/Twi	-		,	Folio		Outside	Dimensions	[

Picklist Print

Apal-17-13 1:06:44 PM

Work Order ID: 100057

100057

Parent Item:

D4005-1

D4005-1

Parent Item Name: Rear Restraint Angle Gutter

Start Date: 4/17/13

Required Date: 5/01/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP rev A 10.01.21 new issue Prelim EC verified by:DD

10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:C 10.11.11

added abrasion strip DD verified by:E IPP Rev:D 12.03.07 as per dwg rev.b

DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M2024T3S.063		Purchased	No			100	sf	125.8800	0.1451	0.916421	1			
M2024T3	S 063								**		Z WI	13.04.	21	

2024-13 063 sheet

Location	<u>Lo</u>	c Oty	Loc Code			
MAT022		125.88				
119916		0.2			7.	
121197		21.34				
123096		11.4				
123654		11.64				
123701		81.3				_
	164	Each	0.0000	I	6	

D2856-100-1100

Manufactured

**

D2856-100-1100

Abrasion Strip cut one at 11.00"

	į		1							1	DQA:	Date	:
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WORK Orac	`` <u></u> -					Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo. -		1			Scrap			Machining	Small Fab		d. Eng. Coor.	Quality Other
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		Crushed/0	Crimped	-		Burrs	\vdash		ions Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
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ļ		Heat Trea	1		_	Countersink	\vdash	Mislabe		i	Positioned V		Joshan
	-	Inspection		Tube	_	Cut Too Short	-	Misread	d .	<u> </u>	Power Loss/	Surge	Other
	-	Ripples in	r			Drill Holes	\vdash	Offset					
	-	Torque W			n L	Drawing			Calibration	1			
		Turning S	1		<u> </u>	Finish	\vdash		Sequence				
		Wave/Tw	ist in Tul	oe		Folio		Outside	Dimensions				

DART AEROSPACE LTD	Work Order:	100057
Description: Rear Restraint Angle Gutter	Part Number:	D4005-1
Inspection Dwg: D4005 Rev: B		Page 1 of 1

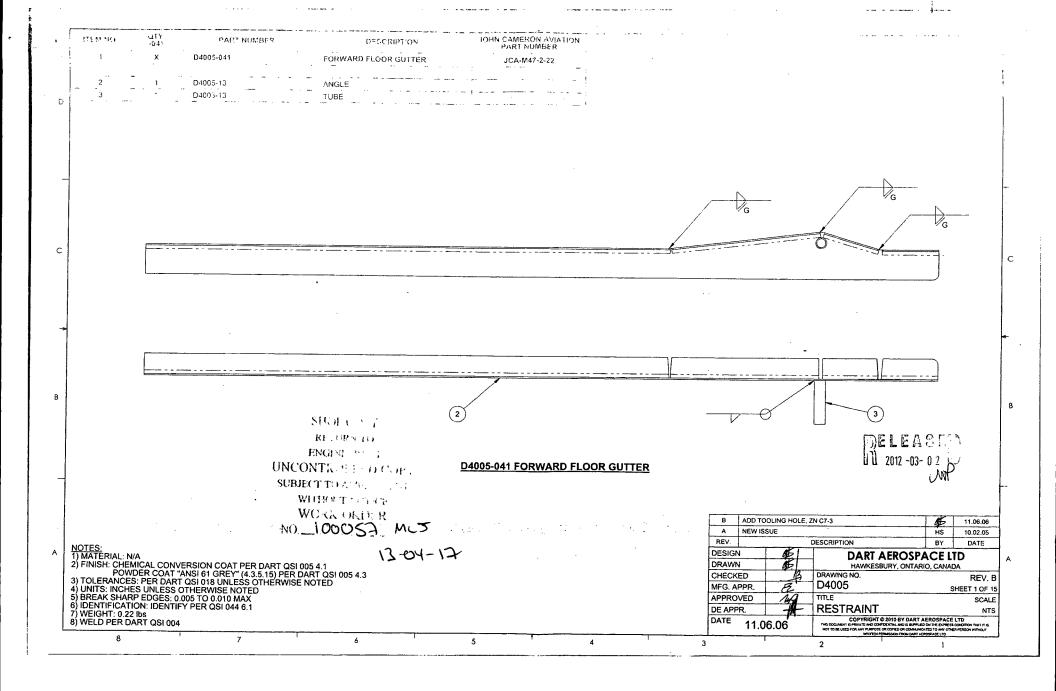
FIRST ARTICLE INSPECTION CHECKLIST

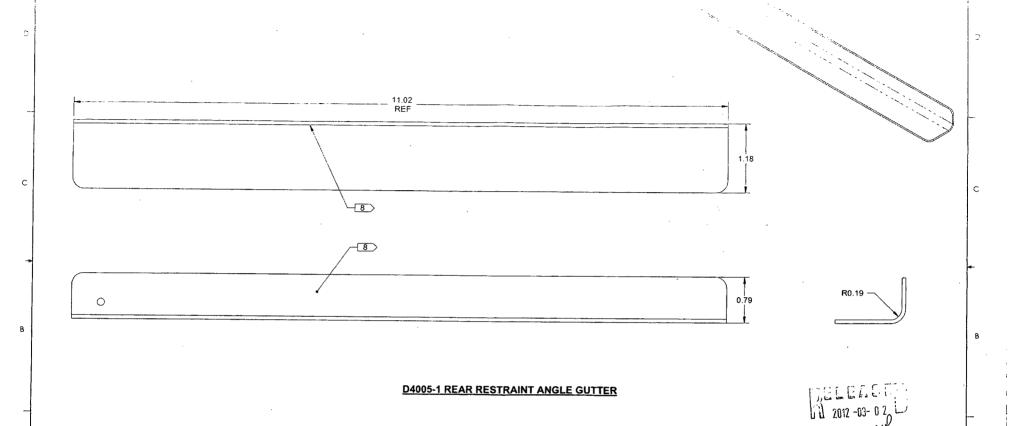
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.81	+/-0.030	1.875			V	JKM-01
11.02	+/-0.030	11.02	/		T	JKM-01 JKM-06
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Measured by:	My	Audited by: DAS	Preliminary Approval:	
Date:	13.04.21	Date: 25 13 (04/27	Date:	

Ì	Rev	Date	Change	Revised	by	Approved
-	Α	11.06.21	New Issue	KJ 11		
	В	13.02.27	Dimensions updated per Dwg Rev B	KJ 🗢	X	/AX
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					·					DQA:	Date:		
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Root Cause	Date	Step	Qty		iption of work order update or Non-conformance		tial f Eng		tion ription	Sign & Date	Verification	QC Inspecto	nr
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İ	Wave/Tw	ist in Tub	oe -	1	Folio		Outside	Dimensions			<u> </u>		





NOTES:
1) MATERIAL: MADE FROM D4005-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.12 lbs
8) COVER THIS SURFACE WITH D2856-100-11 ABRASION STRIP. TRIM EXCESS

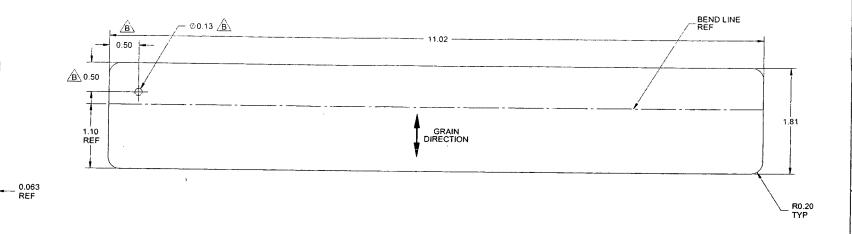
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DESIGN		DART AEROSPACE LTD						
DRAWN	85	HAWKESBURY, ONTARIO, CANADA						
CHECKED		DRAWING NO.	REV. B					
MFG. APPR.	Z	D4005	SHEET 2 OF 15					
APPROVED	14	TITLE	SCALE					
DE APPR.		RESTRAINT	NTS					
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NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.12 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4005 MFG. APPR. SHEET 3 OF 15 TITLE APPROVED SCALE RESTRAINT

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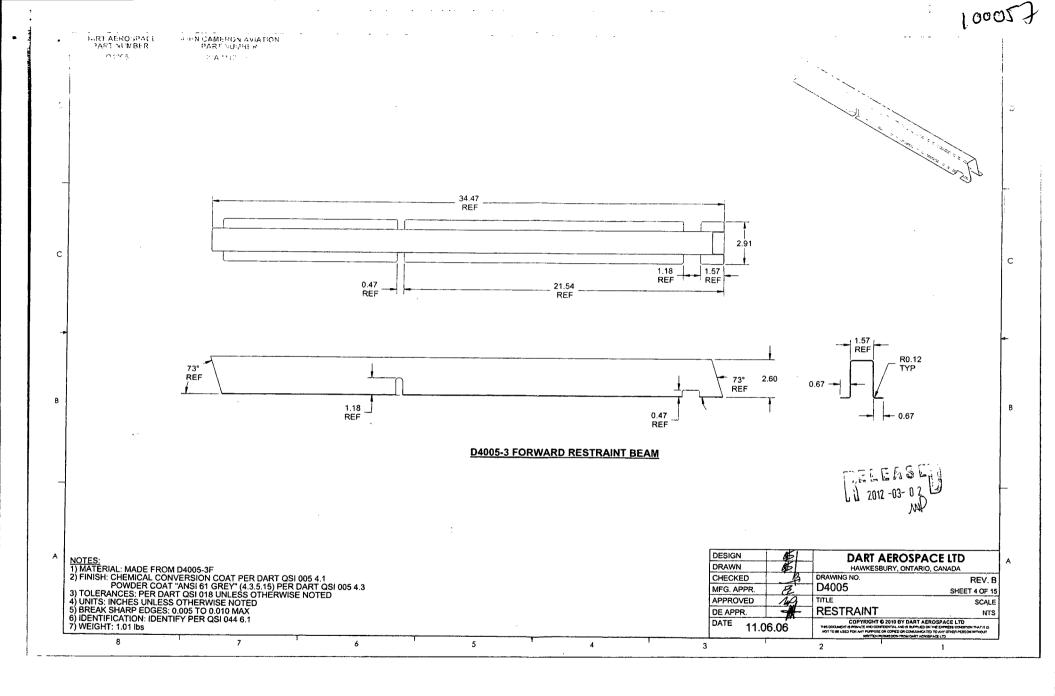
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D4005-1F FLAT PATTERN

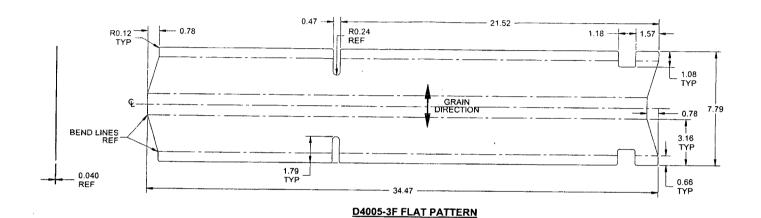
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NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

7) WEIGHT: 1.01 lbs

С

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4005 MFG. APPR. SHEET 5 OF 15 TITLE APPROVED SCALE RESTRAINT

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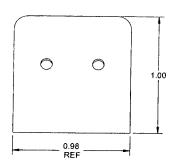
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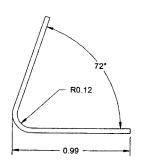
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TOUR CAMERON AVIATION

Hartlitz, Lighten





D4005-5 ANGLE

NOTES:
1) MATERIAL: MADE FROM D4005-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

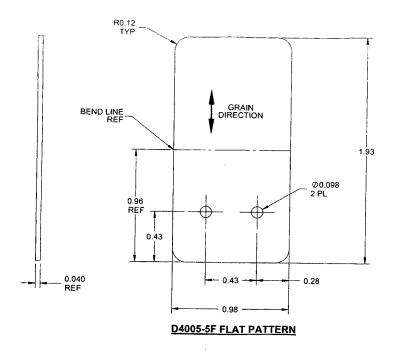
DESIGN DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
MFG. APPR.	E	D4005	SHEET 6 OF 15				
APPROVED	149.	TITLE	SCALE				
DE APPR.	#	RESTRAINT	NTS				
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NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040

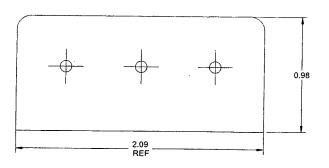
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

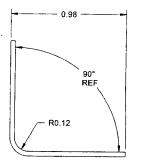
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DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN	15						
CHECKED	B	DRAWING NO.	REV. B				
MFG. APPR.	B	D4005	SHEET 7 OF 1				
APPROVED	14	TITLE	SCALE				
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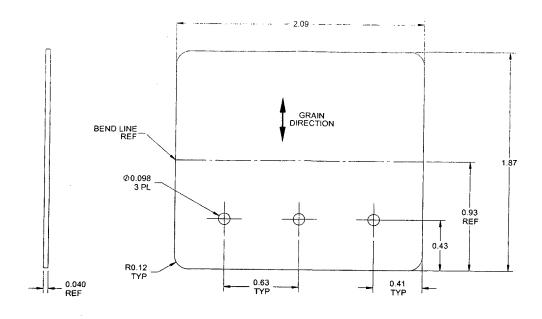
NOTES:
1) MATERIAL: MADE FROM D4005-7F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

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DESIGN	3 5	DART AEROSPACE LTD						
DRAWN	85	HAWKESBURY, ONTARIO, CANADA						
CHECKED	爲	DRAWING NO.	REV B					
MFG. APPR.	B	D4005	SHEET 8 OF 15					
APPROVED	142	TITLE	SCALE					
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D4005-7 ANGLE

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D4005-7F FLAT PATTERN

NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 REF DART SPEC M2024T3S.040
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

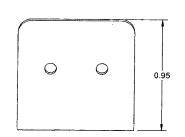
DESIGN	951	DART AEROSPACE LTD					
DRAWN AS		HAWKESBURY, ONTARIO, CANADA					
CHECKED	B	DRAWING NO.	REV B				
MFG. APPR.	E	D4005	SHEET 9 OF 15				
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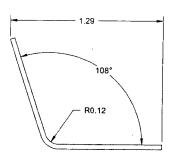
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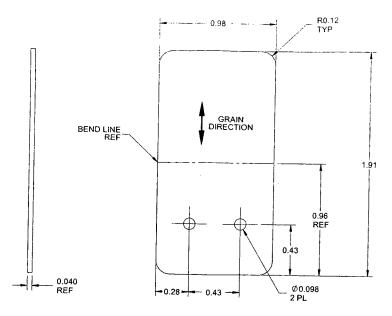
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D4005-9 ANGLE

NOTES:	244						DESIGN DRAWN			VEROSPACE LTD URY, ONTARIO, CANADA
2) FINISH		4005-9F RSION COAT PER DART C QSI 018 UNLESS OTHERW					CHECKED MFG. APPR.	B	DRAWING NO. D4005	REV. B SHEET 10 OF 15
4) UNITS	INCHES UNLESS OF SHARP EDGES: 0.0	THERWISE NOTED	ISE NOTED				APPROVED	NP	TITLE	SCALE
6) IDENT	FICATION: IDENTIFY IT: 0.01 lbs	PER QSI 044 6.1					DE APPR. DATE 11.0		THIS DOCUMENT IS PROVATE AND COMPS NOT TO BE USED FOR ANY PURPOSE O	NTS 2010 BY DART ARROSPACE LTD DEPTIM, AND IS SUPPLED ON THE EDITIES IS CONSTITUTE THE BY COPIED ON COMMANDED TO ANY OTHER PERSON WITHOUT
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D4005-9F FLAT PATTERN

NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

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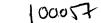
DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4005 CHECKED REV, B MFG. APPR. **SHEET 11 OF 15** APPROVED TITLE SCALE RESTRAINT DE APPR. NTS

DATE 11.06.06

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D4005-11 FINISHING STRIP

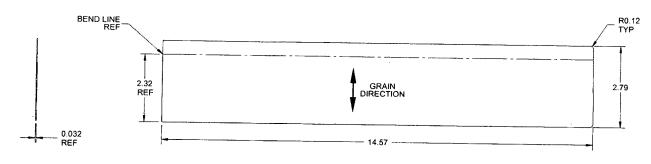
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CON CAMERON AVIATION

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DESIGN	1	DART AEROSPACE LTD					
DRAWN	6	HAWKESBURY, ONT					
CHECKED	13	DRAWING NO.	REV. B				
MFG. APPR.	E	7 D4005	SHEET 12 OF 15				
APPROVED	14	TITLE	SCALE				
DE APPR.	-#	RESTRAINT	NTS				
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D4005-11F FLAT PATTERN

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.032
CD 6061 T6/T62 AI UMINUM SHEET, 0.032 THICK REF DART SPEC M2024T3S.032
OR 6061-T6762 AL UMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS -QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
OR 5052-H32 ALUMINUM SHEET
PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
N/A 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.13 lbs

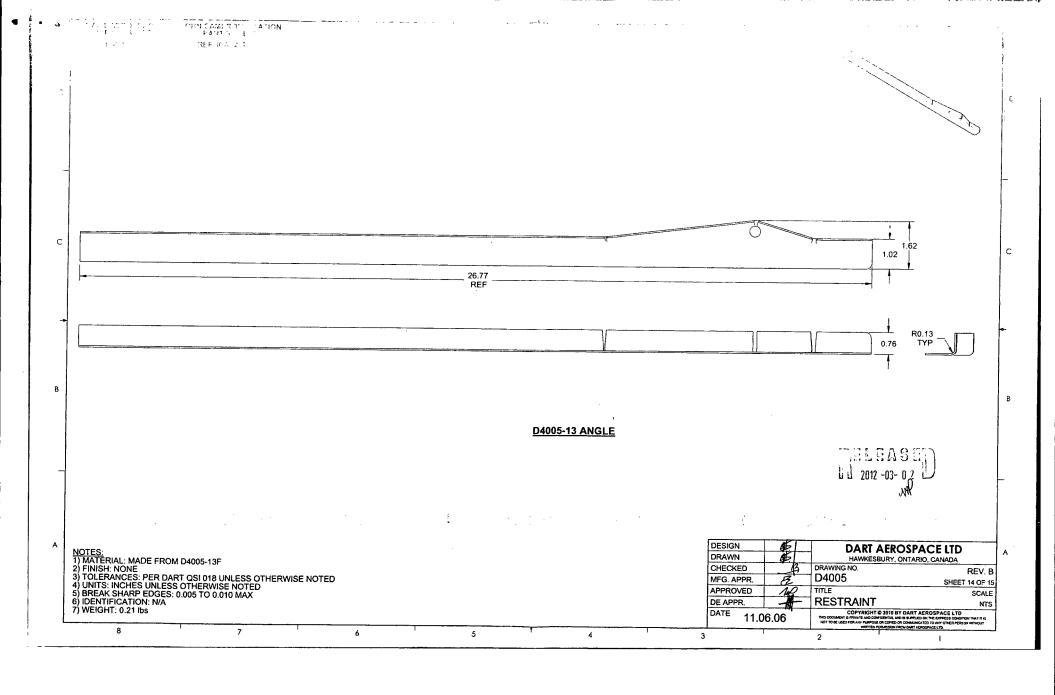
DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4005 MFG. APPR. **SHEET 13 OF 15** APPROVED TITLE SCALE RESTRAINT DE APPR. NTS DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
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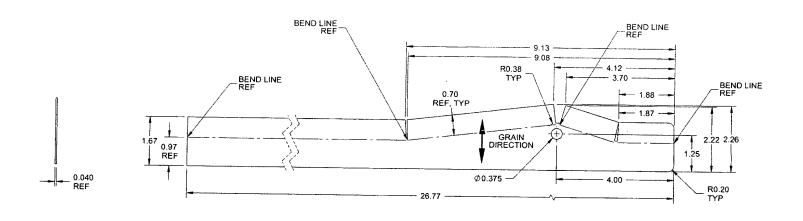
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D4005-13F FLAT PATTERN

NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.040

REF DART SPEC M6061T6S.040
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.21 lbs

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DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4005 MFG. APPR. SHEET 15 OF 15 APPROVED TITLE SCALE RESTRAINT DE APPR. NTS DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
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